

Date: Thursday, 5/11/2006 11:52:10 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 27057		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/11/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/30/2006 Qty: 12 Um: Each		
Previous Run	: 26973					
Written By	<u>Sgt</u> COMMENT Below					
Checked & Approved By	<u>KJ</u> 06.05.11					
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101005	7075-T7351 8.25X5.0X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: _____	B24069 x 12	Sp 06/05/15
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 27057 Double check by: J.G		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	EPA/06/05/11	J.G 06/05/16 12
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	EPA/06/05/11	J.G 06/05/16 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: Date: 06/05/05

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 5/11/2006 11:52:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27057

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



SP 06/05/19

S.P. / S.G.

06/05/16

12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

7/2 06/05/23

12

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06:05:24

12

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06/05/24

12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AC 06/05/24

(12)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST479*

DA

06/05/24

12

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD

06/05/25

12

Job Completion



C 06/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD				Work Order:	27057
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.745		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.748	1.749	1.745		
E	7.990	8.010		8.002	8.004	8.003	8.003		
F	0.490	0.510		0.501	0.502	0.501	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.501	0.502	0.496		
J	1.174	1.184		1.180	1.180	1.180	1.178		
K	0.558	0.578		0.569	0.568	0.567	0.566		
L	1.174	1.184		1.180	1.179	1.179	1.178		
M	1.490	1.500		1.499	1.498	1.497	1.495		
N	2.495	2.505		2.499	2.497	2.496	2.499		
O	3.869	3.879		3.872	3.871	3.872	3.871		
P	0.115	0.135		0.121	0.120	0.119	0.121		
Q	0.115	0.135		0.125	0.124	0.125	0.125		
R	0.240	0.260		0.250	0.249	0.248	0.251		
S	0.115	0.135		0.121	0.119	0.119	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.962	2.961	2.960		
V	0.230	0.250		0.241	0.242	0.241	0.239		
W	0.115	0.135		0.126	0.127	0.126	0.124		
X	0.307	0.312		0.311	0.312	0.311	0.311		
Y	0.760	0.765		0.761	0.761	0.761	0.765		
Z	0.352	0.372		0.364	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.560		
AB	0.615	0.635		0.633	0.630	0.629	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.247	0.247	0.244		
AE	1.375	1.395		1.387	1.387	1.384	1.385		
AF	0.115	0.135		0.132	0.130	0.130	0.135		
AG	0.240	0.280		0.244	0.247	0.246	0.260		
AH	0.240	0.260		0.251	0.250	0.251	0.245		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G /	/	Audited by:	Jin
Date:	06/05/17	/	Date:	06/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	Jin

DART AEROSPACE LTD	Work Order:	27057
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.745	1.748	1.746		
C	3.495	3.505		3.496	3.499	3.496	3.496		
D	1.745	1.755		1.748	1.745	1.748	1.746		
E	7.990	8.010		8.003	8.000	8.002	8.003		
F	0.490	0.510		0.497	0.497	0.498	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.493	0.494	0.499	0.499		
J	1.174	1.184		1.179	1.175	1.178	1.177		
K	0.558	0.578		0.563	0.562	0.565	0.569		
L	1.174	1.184		1.179	1.179	1.178	1.178		
M	1.490	1.500		1.492	1.494	1.493	1.493		
N	2.495	2.505		2.495	2.497	2.495	2.496		
O	3.869	3.879		3.874	3.874	3.873	3.872		
P	0.115	0.135		0.125	0.124	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.245	0.250		
S	0.115	0.135		0.125	0.122	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.966	2.960	2.960		
V	0.230	0.250		0.232	0.238	0.233	0.239		
W	0.115	0.135		0.122	0.124	0.118	0.118		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.368	0.366	0.358		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.242	0.250	0.243		
AE	1.375	1.395		1.385	1.385	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.251	0.248	0.248		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.030	0.030		
Accept/Reject									

Measured by:	3-G/EP	Audited by:	TJL
Date:	06/05/17	Date:	06/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL

DART AEROSPACE LTD	Work Order:	271056
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.748	1.749	1.749		
C	3.495	3.505		3.498	3.499	3.498	3.499		
D	1.745	1.755		1.745	1.748	1.749	1.749		
E	7.990	8.010		8.000	8.001	8.004	8.002		
F	0.490	0.510		0.497	0.498	0.493	0.494		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.498	0.497	0.496		
J	1.174	1.184		1.175	1.178	1.177	1.176		
K	0.558	0.578		0.566	0.564	0.567	0.566		
L	1.174	1.184		1.175	1.178	1.179	1.176		
M	1.490	1.500		1.497	1.493	1.493	1.494		
N	2.495	2.505		2.499	2.498	2.500	2.495		
O	3.869	3.879		3.873	3.873	3.871	3.872		
P	0.115	0.135		0.126	0.129	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.246	0.249	0.250		
S	0.115	0.135		0.126	0.123	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.189	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.239	0.237	0.237		
W	0.115	0.135		0.122	0.122	0.121	0.122		
X	0.307	0.312		0.311	0.310	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.365	0.363	0.366		
AA	0.470	0.530		0.500	0.503	0.500	0.500		
AB	0.615	0.635		0.623	0.626	0.625	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.257	0.246	0.241	0.241		
AE	1.375	1.395		1.388	1.382	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.246	0.246	0.246		
AI	2.000	2.020		W/0	W/0	W/0	W/0		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	<i>SP</i>	Audited by:	<i>JML</i>
Date:	06/05/19	Date:	06/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i>	<i>JML</i>

RELEASED

05.12.06

